

Date: Wednesday, 11/21/2007 12:47:36 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	35915				
Estimate Number	10530				
P.O. Number	N/A	Part Number	D2571		
This Issue	11/21/2007	S.O. No.	N/A		
Prsht Rev.	NC	Drawing Number	D2571 REV E		
First Issue	N/A	Project Number	N/A		
Previous Run	34812	Type	MACHINED PARTS		
Written By		Drawing Revision	E		
Checked & Approved By		Material	N/A		
Comment	Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ				
Due Date	1/15/2008				
Qty:	12	Um:	Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	

Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2571

Ensure that grain is along 7.75" length

Batch No: B31389*Mk 07/12/27*

(12)

2.0	HAAS1	-HAAS CNC VERTICAL MACHINING #1	
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 35915 Double check by: DKP

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

Mk 1 SF 08/01/03

(12)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
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Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

Mk 1 SF 08/01/03

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/01/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:47:36 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/NBOARD)

Job Number: 35915

Part Number: D2571

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 08/01/04

(12)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



12X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m/l

08/01/08

7.0 POWDER COATING POWDER COATING



M102316



12X

Comment: POWDER COATING

✓ Powder **SANDTEX GREEN**
(Ref: 4.3.5.1) as per QSI 005 4.3

m/l

08/01/09

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



91



(12)

Comment: INSPECT POWDER COAT

08-01-09

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

8/1/09 SD

12X

(12)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

No seal 11

Job Completion



U 28-06-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35915
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.446	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.991	8.000	8.000		
F	0.490	0.510		0.501	.500	.500	.500		
G	0.257	0.262	DT8683	0.260	.258	.257	.259		
H	0.375	0.380	DT8684	0.377	.377	.377	.377		
I	0.490	0.510		0.499	.500	.500	.500		
J	1.174	1.184		1.178	1.180	1.180	1.180		
K	0.558	0.578		0.567	.568	.577	.570		
L	1.174	1.184		1.178	1.180	1.180	1.180		
M	1.490	1.500		1.494	1.500	1.500	1.500		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	3.869	3.879		3.872	3.872	3.872	3.872		
P	0.115	0.135		0.126	.126	.127	.127		
Q	0.115	0.135		0.135	.130	.130	.130		
R	0.240	0.260		0.249	.246	.251	.251		
S	0.115	0.135		0.129	.129	.129	.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.236	.240	.241	.240		
W	0.115	0.135		0.120	.134	.131	.130		
X	0.308	0.313		0.310	.311	.311	.311		
Y	0.760	0.765		0.760	.760	.760	.760		
Z	0.352	0.372		0.365	.365	.365	.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	.632	.632	.632		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	.250	.250	.250		
AE	1.375	1.395		1.388	1.386	1.386	1.386		
AF	0.115	0.135		0.127	.127	.127	.127		
AG	0.240	0.280		0.250	.250	.260	.260		
AH	0.240	0.260		0.247	.247	.250	.250		
AI	2.000	2.020		2.002	2.001	2.000	2.000		
AJ	0.023	0.043		0.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>Amf / JF</i>	Audited by:	<i>SA</i>
Date:	03/12/25	Date:	08/01/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>Amf / JF</i>

DART AEROSPACE LTD	Work Order:	35915
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5A	62	73	44	By	Date
A	0.438	0.443	DT8682	.440	.440	.440	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	0.500	.503	.504		
G	0.257	0.262	DT8683	.260	.260	.260	.260		
H	0.375	0.380	DT8684	.376	.377	.377	.377		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.500	1.500	1.500	1.500		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.125	.125	.125	.135		
R	0.240	0.260		.250	.250	.250	.248		
S	0.115	0.135		.125	.125	.125	.132		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.963	2.963	2.963	2.963		
V	0.230	0.250		.240	.240	.240	.238		
W	0.115	0.135		.125	.125	.125	.133		
X	0.308	0.313		.311	0.310	0.310	.310		
Y	0.760	0.765		.760	0.760	.760	.760		
Z	0.352	0.372		.360	0.364	0.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.629	.629	.633		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.247		
AE	1.375	1.395		1.385	1.385	1.385	1.388		
AF	0.115	0.135		.125	.125	.125	.130		
AG	0.240	0.280		.260	.260	.280	.260		
AH	0.240	0.260		.268	.250	.250	.248		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	8.5	Audited by:	SA
Date:	07/12/04 / 08/01/02	Date:	08/01/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SA

DART AEROSPACE LTD	Work Order:	38915
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9A	.210	.211	.212	By	Date
A	0.438	0.443	DT8682	.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.001	8.001		
F	0.490	0.510		.500	.500	.501	.501		
G	0.257	0.262	DT8683	.258	.260	.260	.260		
H	0.375	0.380	DT8684	.377	.376	.377	.377		
I	0.490	0.510		0.500	.501	.501	.501		
J	1.174	1.184		1.180	1.179	1.179	1.180		
K	0.558	0.578		0.568	.569	.568	.568		
L	1.174	1.184		1.160	1.179	1.179	1.180		
M	1.490	1.500		1.500	1.494	1.499	1.500		
N	2.495	2.505		2.500	2.499	2.500	2.500		
O	3.869	3.879		3.874	3.873	3.873	3.873		
P	0.115	0.135		.125	.124	.125	.125		
Q	0.115	0.135		0.135	.135	.135	.135		
R	0.240	0.260		.250	.248	.250	.250		
S	0.115	0.135		0.132	.132	.132	.132		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.963	2.960	2.963	2.963		
V	0.230	0.250		0.238	.241	.240	.241		
W	0.115	0.135		0.132	.132	.130	.130		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.360	.360	.360	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.247	.245	.245		
AE	1.375	1.395		1.388	1.386	1.386	1.386		
AF	0.115	0.135		0.130	.130	.130	.130		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		0.247	.248	.258	.260		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	8-5	Audited by:	SD
Date:	07/12/31	Date:	08/01/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SD

RELEASED

05.12.07

